

Date: Thursday, 12/13/2007 2:38:56 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	36324	Part Number	D2573		
Estimate Number	10533	Drawing Number	D2573 REV E		
P.O. Number	NA	Project Number	N/A		
This Issue	12/13/2007	S.O. No.	NA		
Prsht Rev.	NC	Drawing Revision	E		
First Issue	NA	Material	NA		
Previous Run	35933	Due Date	1/10/2008	Qty:	16 Um: Each
Written By					
Checked & Approved By					
Comment	Est: 1 As Per RevE 06-01-27 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101007	7075-T7351 8.25X7.75X2.5		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>631389</u>		<u>SF 08/01/08</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>36824</u> Double check by: <u>J.L.</u>		
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.		<u>SF 08/01/08</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574		<u>SF 08/01/08</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<u>SF 08/01/08</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/01/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 2:38:56 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 36324

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 08/01/14

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



16X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-h

08/01/15

7.0 POWDER COATING POWDER COATING



16X

M106379

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h 08/01/16

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



16

Comment: INSPECT POWDER COAT

FZ 08/01/16 (16)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 433

8/1/11 SD (16)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



16

Comment: FINAL INSPECTION/W/O RELEASE

108/01/17

Job Completion



U 28/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	36324
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.991	7.999	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.500	.501	.501	.501		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.501	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.125	.135	.135	.135		
R	0.240	0.260		.250	.258	.258	.257		
S	0.115	0.135		.125	.119	.119	.120		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.231	3.234	3.232	3.233		
V	0.230	0.250		.230	.240	.240	.240		
W	0.115	0.135		.129	.129	.129	.129		
X	0.308	0.313		.310	.311	.310	.310		
Y	0.760	0.765		.760	.760	.760	.764		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.627	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.520	1.520	1.520	1.520		
AF	0.115	0.135		.125	.125	.135	.135		
AG	0.240	0.280		.246	.260	.260	.260		
AH	0.240	0.260		.240	.250	.250	.250		
AI	2.000	2.020		2.000	2.009	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: SF RG  
Date: 08/01/08

Audited by: SA  
Date: 08/10/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>SA</u> <u>JLM</u>

DART AEROSPACE LTD				Work Order:	36324
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5.8	6.8	7.8	8.4		
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		.503	.503	.503	.503		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.377	.377	.376	.376		
I	0.490	0.510		.503	.503	.503	.503		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.567	.567	.569	.569		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.375	1.375	1.375	1.375		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.258	.256		
S	0.115	0.135		.130	.130	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.233	3.233	3.233		
V	0.230	0.250		.245	.245	.245	.245		
W	0.115	0.135		.130	.130	.130	.130		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.635	.635	.635	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.511	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.255	.255		
AI	2.000	2.020		2.001	2.001	2.010	2.010		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	8F 1B6
Date:	08/01/09

Audited by:	SD
Date:	08/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

DART AEROSPACE LTD				Work Order:	36324
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.4410	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.002		
F	0.490	0.510		.506	.506	.507	.505		
G	0.257	0.262	DT8683	.259	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.377	.377	.377		
I	0.490	0.510		.503	.503	.503	.503		
J	1.174	1.184		1.179	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.179	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.123	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.255	.255	.255	.255		
S	0.115	0.135		.122	.122	.122	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.233	3.233	3.233		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.125	.125	.125	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.764	.764	.760	.760		
Z	0.352	0.372		.362	.362	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.635	.630	.635	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.255	.255	.255	.255		
AE	1.500	1.520		1.515	1.518	1.515	1.515		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.005	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: 361  
Date: 08/07/14

Audited by: SD  
Date: 08/07/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>JK</u> <u>JLM</u>

DART AEROSPACE LTD				Work Order:	36324
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

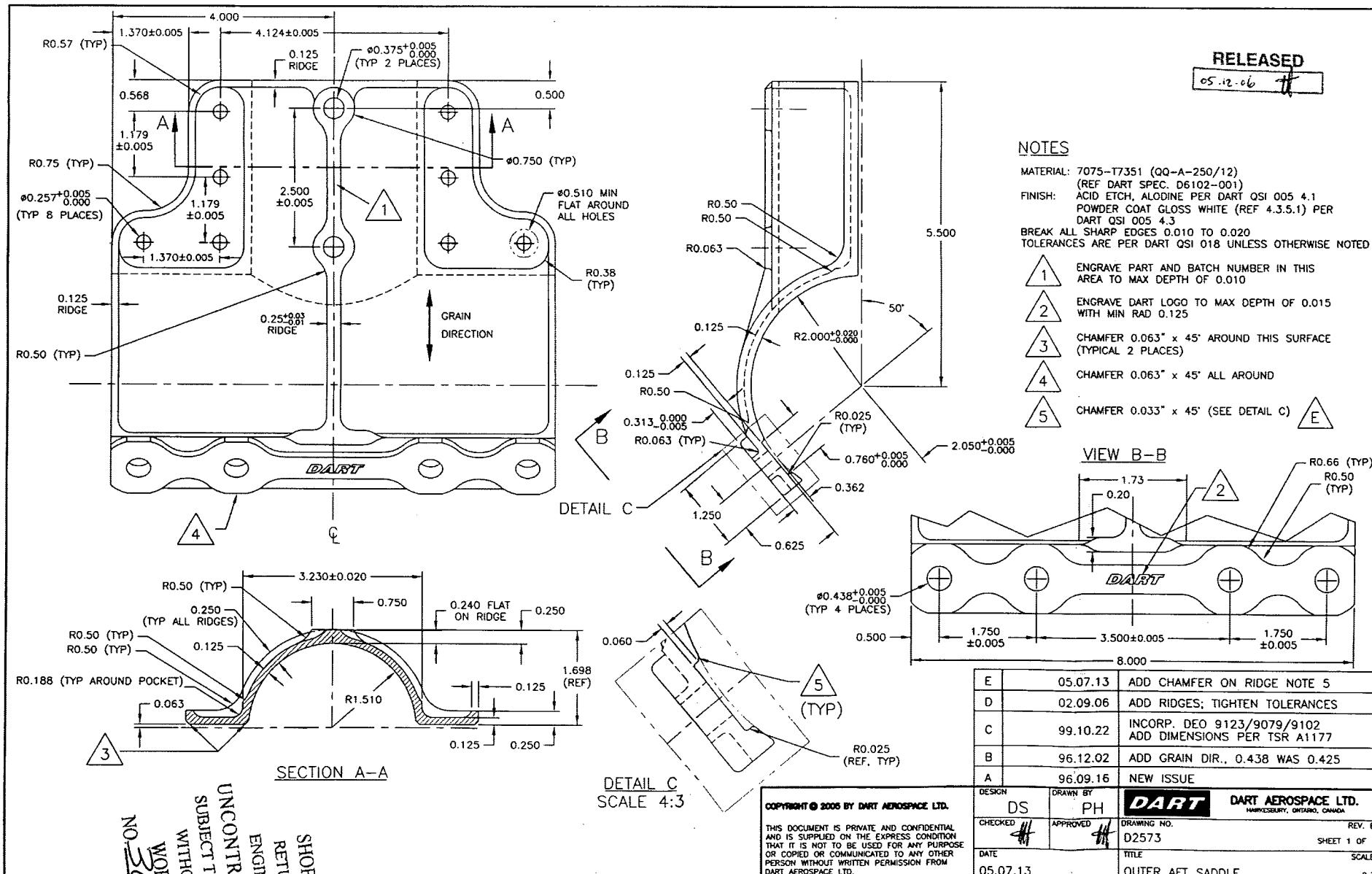
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				13 1	14 2	15 3	16 4		
A	0.438	0.443	DT8682	.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.377	.377	.377	.377		
I	0.490	0.510		.502	.502	.502	.502		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.255	.255	.255	.250		
S	0.115	0.135		.126	.127	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.233	3.233	3.233	3.233		
V	0.230	0.250		.241	.245	.245	.245		
W	0.115	0.135		.128	.128	.128	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.570	1.510	1.510	1.510		
AF	0.115	0.135		.121	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.250	.250	.250		
AI	2.000	2.020		2.001	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: *8/*  
Date: *08/01/12*

Audited by: *SA*  
Date: *08/01/14*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>28</i>	<i>SA</i>



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 WORK ORDER  
 NO. 36324

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